

Work Order ID 54222

December 3, 2009 1:03:53 PM

Page 1

Item ID: d3608-3F
Revision ID: ~~PB1~~ 10/12/09
Item Name: Upper Boubler

PRELIMINARY ISSUE
10/12/09

Accept

Start Date: 12/03/09 Start Qty: 1.00
Required Date: 12/04/09 Req'd Qty: 1.00

Cust Item ID:
Customer:

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:



Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3608

Rev A

~~PB1~~ 10/12/09

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3608
Deburr if necessary

Dwg Rev: ~~PCE~~

Prog Rev: Lim 2-

B9-12-4

①

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B9-12-4

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

27 804/12/04

④ φ

DART AEROSPACE LTD		Work Order:	54222
Description: Upper Double		Part Number:	D3608-3F
Inspection Dwg: D3608-3F Rev: per Liny P131		Page 1 of 1	

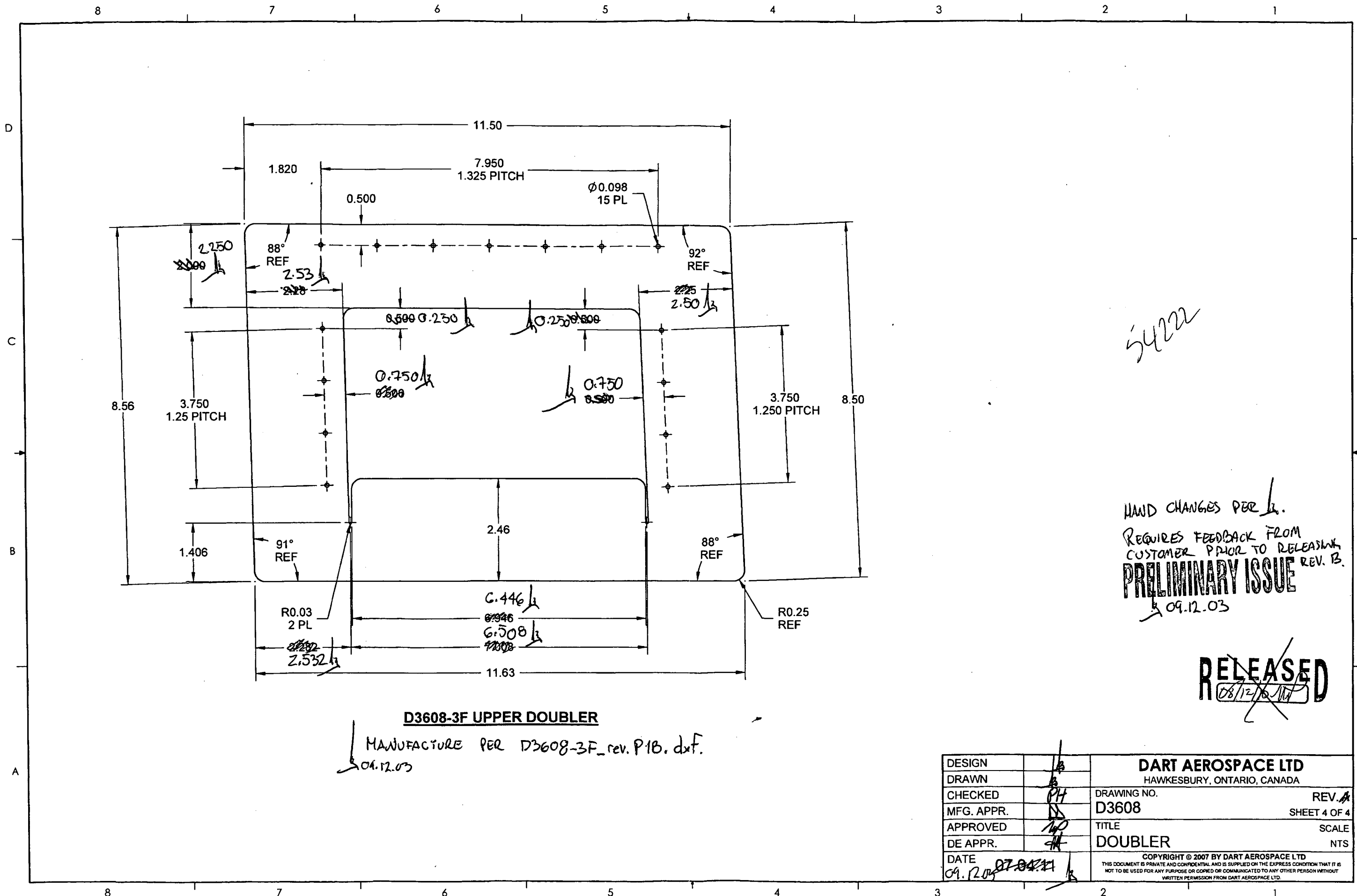
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.100	✓			
1.820	± .010	1.818	✓			
.500	± .010	.494	✓			
7.950	± .010	7.947	✓			
1.325	± .010	1.323	✓			
11.50	± .030	11.511	✓			
.750	± .010	.750	✓			
2.50	± .030	2.504	✓			
.750	± .010	.753	✓			
8.50	± .020	8.502	✓			
1.250	± .010	1.251	✓			
3.750	± .010	3.751	✓			
2.46	± .030	2.460	✓			
6.446	± .010	6.441	✓			
6.508	± .010	6.508	✓			
11.63	± .030	11.617	✓			
2.532	± .010	2.535	✓			
1.406	± .010	1.406	✓			
8.56	± .030	8.552	✓			
2.53	± .030	2.532	✓			
2.250	± .010	2.255	✓			
.040	± .010	.037	✓			

Measured by:	R	Audited by:	S	Prototype Approval:	N/A
Date:	9-12-04	Date:	09/12/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



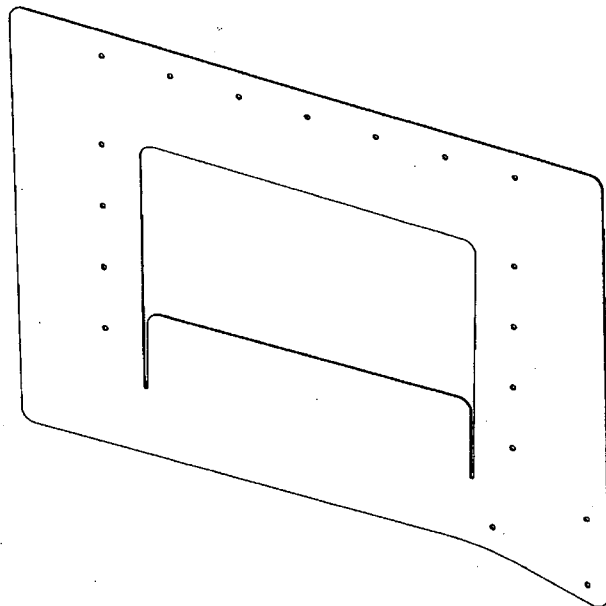
8 7 6 5 4 3 2 1

D

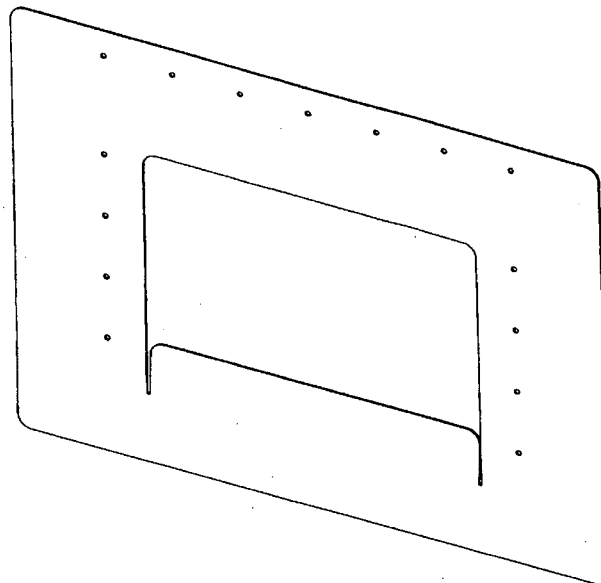
C

B

A



D3608-1 LOWER DOUBLER



D3608-3 UPPER DOUBLER

RELEASED
2010-02-10

NOTES:

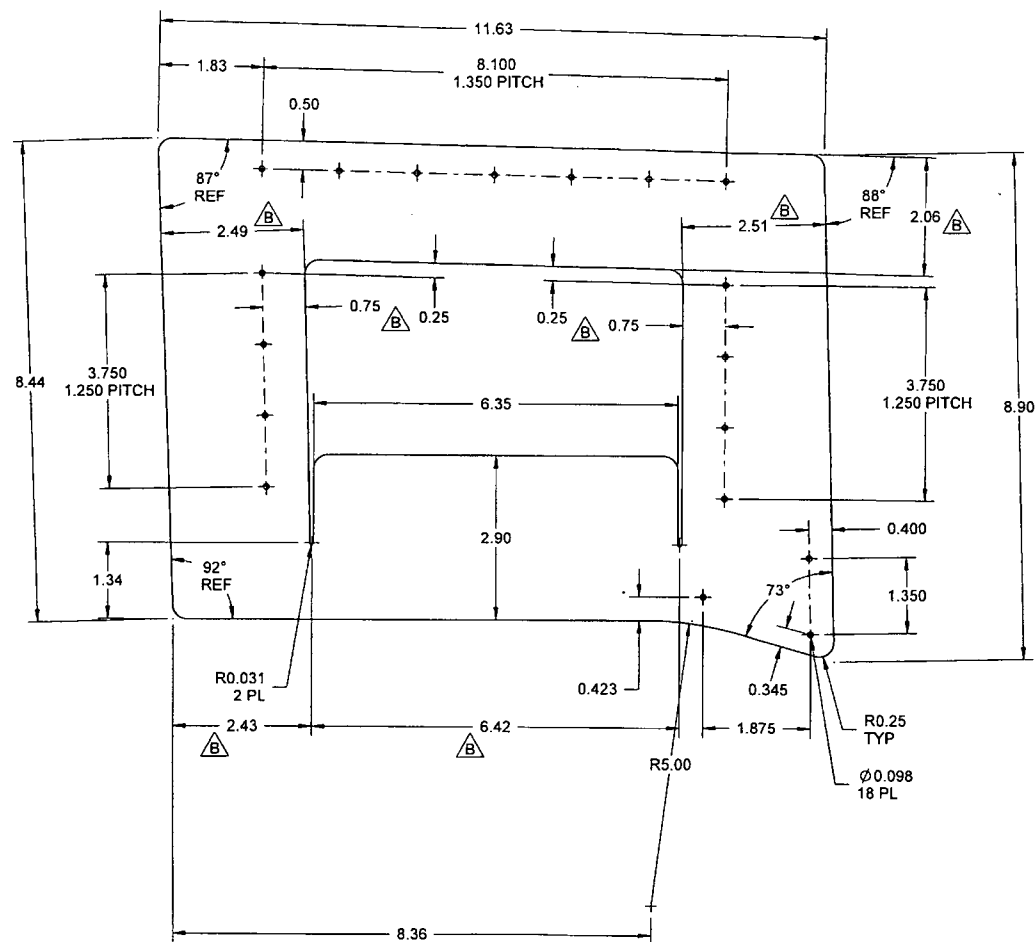
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK
PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3608-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.80 lbs EACH

54222

B	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 INWARD; ELIMINATED D3608-1F/3F; DELETED BENDING DETAILS. REASON: D3608-1/-3 NOW SOLD TO CUSTOMERS UNBENT PER PAR#09-097.		MB	10.02.05
A	NEW ISSUE		MB	07.04.11
REV.	DESCRIPTION		BY	DATE
DESIGN	DRAWN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	MFG. APPR.		DRAWING NO. D3608	
APPROVED	DE APPR.		REV. B SHEET 1 OF 3	
DATE	10.02.05		TITLE DOUBLER SCALE NTS	

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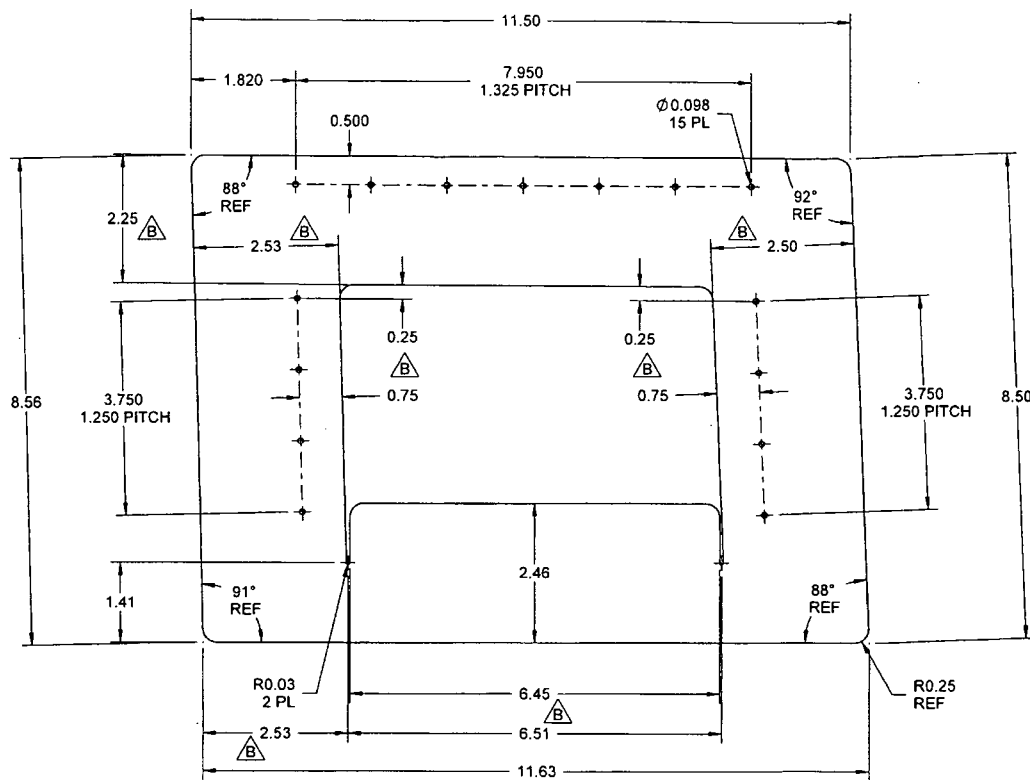


D3608-1 LOWER DOUBLER

RELEASED
2010-02-10

54222

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3608	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
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D3608-3 UPPER DOUBLER

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2010-02-18

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3608	SHEET 3 OF 3
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